

Work Order ID 85480

June-08-12 10:12:43 AM

85480

Page 1

Item ID: D2741

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade, 350 Skidtube

Start Date: 08/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/06/08 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2741	Rev C								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 13.850" long +0.063" -0.000"								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA108								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

RT 12-06-15 40

PO/PAZ 12/06/16

40 0

PO/PAZ 12/06/16

40 0

Work Order ID 85480

85480

Page 2

June-08-12 10:12:43 AM

Item ID: D2741

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Blade, 350 Skidtube

Stop *NS2*

Start Date: 08/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Deburr2-Bend per Dwg D2741								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

B.A 12/06/18

40

0

40

0

SB 12/06/20

40

12/06/21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unauthorized <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many			General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing			Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material		<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other 	

Work Order ID 85480

85480

Page 3

June-08-12 10:12:43 AM

Item ID: D2741

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Blade, 350 Skidtube

Stop *NS2*

Start Date: 08/06/2012 Start Qty: 40.00 *40*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 40.00 *40*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Outsource process - Heat Treat	0.00							
160									
Outsource I		0.00							
Outsource process - Heat Treat	Memo Issue P/O: 17274 Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required Sand blast parts								GA 12/06/21 (40)
170	Receive & Inspect for Damage & Mat'l Certs	0.00							
170									
Packaging		0.00							
Packaging	Memo Ensure Test report or Certification attached								CUA/H10 (40)
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC		0.00							
Quality Control	Memo								cauty x16

DA 16 9-8 17/06/13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear	Hardware	General	Maintenance
<input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

Work Order ID 85480

85480

Page 4

June-08-12 10:12:43 AM

Item ID: D2741

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade, 350 Skidtube

Stop

NS2

Start Date: 08/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00

190

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Pass in deburring machine 2-Grind off edges

195

0.00

195

HandFinish

Memo

0.00

Hand Finishing

clean with wash & wipe to remove oil

200

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

4000 F

10:15

40 16 12-8-14

40 X Ø 12/08/14

m121841

Work Order ID 85480

85480

Page 5

June-08-12 10:12:43 AM

Item ID: D2741

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Blade, 350 Skidtube

Stop *NS2*

Start Date: 08/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

40x 6 12/08/14

220

Identify as per dwg & Stock Location: 466

0.00

220

Packaging

Memo

0.00

Packaging

12/8/14

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

MLJ 12/08/14

MLJ 12/08/14

Picklist Print

June-08-12 10:12:46 AM

Page 1

Work Order ID: 85480

85480

Parent Item: D2741

D2741

Parent Item Name: Blade, 350 Skidtube

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev: D00.11.15Removed P/O turning - in house processEC

IPP Rev: E 06-03-20 As Per Rev C

IPP Rev: F 06.04.20Added grinding after heat treating EC

JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NB0.500X03.00 0		Purchased	No			100	f	62.1200	1.1541	48.59368			

M4130NB0.500X03 000

4130 Bar 0.500 x 3.00

**

EC 12-06-15

Location	Loc Qty	Loc Code
MAT	48	
121739	48	
MAT034	14.12	
118585	12.09	
119269	2.03	

x 48

2.03

PD

12/06/17

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

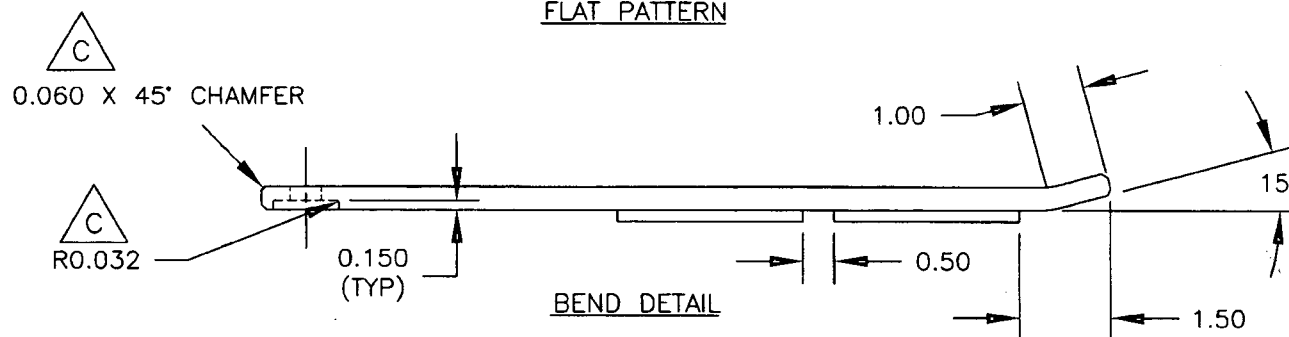
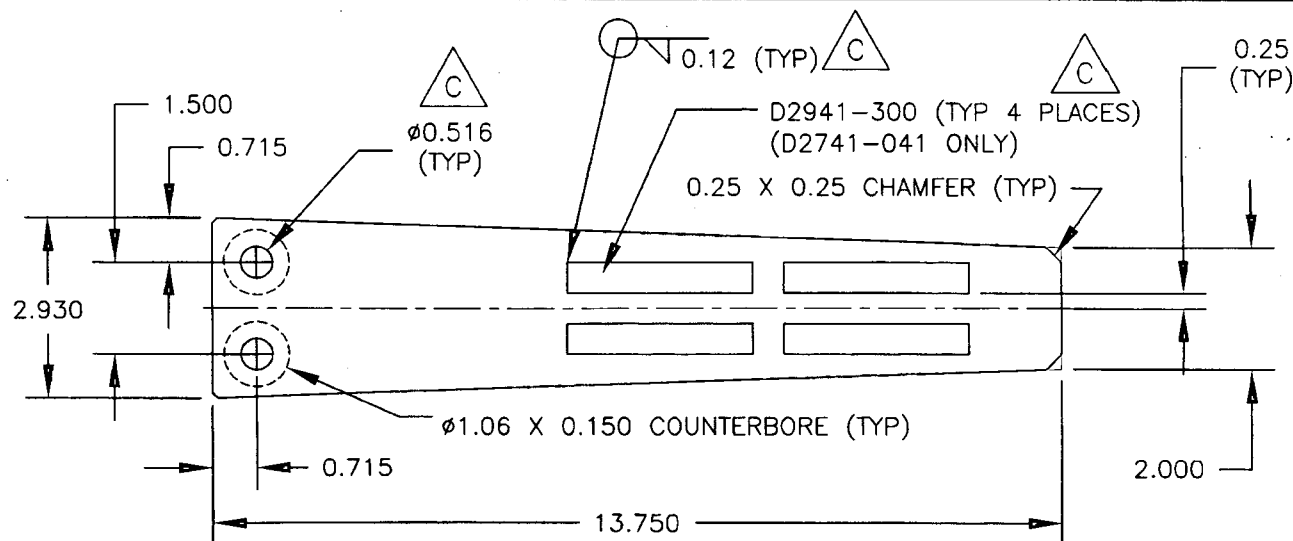
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____



RELEASED
06 02 07



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

05480 MLJ
12/06/08

D2741 BLADE

- 1) MATERIAL: AISI 4130 STEEL 0.375 THICK
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)
MIN. YIELD TENSILE STRENGTH = 141 ksi
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.030 TO 0.060
- 6) TO MAKE D2741-041, WELD D2941-300 (4) AS SHOWN ABOVE.
REMOVE POWDER COAT FROM SURFACE OF D2941-300
- 7) TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
04	04	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
06.01.12	06.01.12	D2741
DATE	TITLE	REV. C
06.01.12	BLADE	SHEET 1 OF 1
A	NEW ISSUE	SCALE
B	CHANGE C'SINK TO C'BORE	1:3
C	LARGER HOLE, ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS	



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ

ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité
Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
177152	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO17276		4130		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN HARDEN AND TEMPER SAE AMS 2759/1 REV.E				
EXIGENCE / requirement	SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed		RÉSULTATS DE TESTS / results	
HARDNESS	34 - 40 HRC		38 - 40 HRC	
TENSILE (KSI)	152 - 182 KSI		171 - 182 KSI	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	138	D2741 BLADE REV. : C REFERENCE: 85480 NOTE: PLEASE SAND BLAST PART AFTER HEAT TREAT CONTENANT: 2 BOÎTES DE CARTON		

COMMENTAIRES / comments

ALL THE HEAT TREATMENT PROCESSING PERFORMED ON THIS ORDER WAS ACCOMPLISHED USING HEAT TREATMENT EQUIPEMENT THAT MEETS THE REQUIREMENTS OF AMS 2759. ALL THE HEAT TREATMENT OPERATIONS WERE ACCOMPLISHED IN ACCORDANCE WITH THE REQUESTED/REQUIRED HEAT TREATMENT SPECIFICATION AND ALL REQUIRED VERIFICATIONS TEST HAVE BEEN PERFORMED AND DOCUMENTED. NO UNAUTHORIZED CHANGES OR DEVIATIONS TO REQUIRED HEAT TREATMENT SPECIFICATIONS OR PROCEDURES HAVE BEEN PERFORMED.

CERTIFIÉ par / Certified by: Isabel Glava  DATE: 2012-08-07



Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Tél. : 450 473-1884
Télécopieur/Fax administration : 450 491-5498
Télécopieur/Fax production : 450 491-6454

Certificat de Conformité **Certificate of Compliance**

BON DE TRAVAIL order	CHARGEMENT load
177152	1

CLIENT / customer : 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
FO17278		4130		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SEL HARDEN
HARDEN AND TEMPER
SAE AMS 2759/1 REV.E

RIGUEUR / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

HARDNESS	34 - 40 HRC	40	38 - 40 HRC
TENSILE (KSI)	152 - 182 KSI		171 - 182 KSI

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	138	D2741 BLADE REFERENCE: 85480 NOTE: PLEASE SAND BLAST PART AFTER HEAT TREAT CONTENANT: 2 BOÎTES DE CARTON

COMMENTAIRES / comments

CERTIFIÉ par / Certified by:

[Signature]



DATE: 2012-08-07